

Work Order ID 53062



October 22, 2009 1:59:55 PM

Page 1

Item ID: D130-780-042

Accept



Setup Start



Revision ID: B

Stop



Item Name: SPACEPOD RH

Stop



Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *PL*Date: *09-10-22*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D130-780	B								

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels per PPP D130-780-042 CHG 003

10-8-17

110 0.00



Pick Kit

Memo

0.00

Packaging

0.00

Packaging

10/18/17 sf

120 0.00



Memo

0.00

Small Fab

- Assemble as per dwg D3188,
- use door to tranfer drill hole location.
- Install inserts

Small Fab

10-08-16

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Item ID: D130-780-042

Accept



Setup Start



Revision ID: B

Stop



Item Name: SPACEPOD RH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

10/08/16



QC

Memo

0.00

10/08/16

Quality Control

140

Wing Walk as per dwg QSI005 4.4 Batch 15028

0.00

10-08-16



HandFinish

Memo

0.00

Hand Finishing

TOP SURFACE OF POD

150

QC3- Inspect Part Finish

0.00

10-08-16



QC

Memo

0.00

Quality Control

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Item ID: D130-780-042

Accept



Setup Start



Revision ID: B

Stop



Item Name: SPACEPOD RH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Pick Kit

0.00

10/8/10

Packaging

Memo

0.00

Packaging

Pto →

170



QC4- 100% Inspect kits for completeness

0.00

S 10/8/10

A

QC

Memo

0.00

Quality Control

180



0.00

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D130-780-042
Location: 115
PPP Rev: 10/8/10

10/8/10 C 10/8/10

W/O: 53062

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/8/17	# 100	<p>Perm. Change</p> <p>Part(s) missing on part list to Part List ADD to Kit</p> <p>- D3815-5 B# <u>61318</u> x3 per kit ✓</p> <p>- MS24694554 B# <u>11532L</u> x6 per kit - ✓</p> <p>- A3235-020-935 B# <u>106150</u> x8 per kit - ✓</p> <p>- MS2105913 B# <u>114718</u> x10 per kit - ✓</p>	SL SC	10/8/17 10/8/17			F 10/8/17
10/8/17	# 100	update w/o + Bom. ADD copy of new Bom for ref.	AA	10.09.14			S/10/08/17

Part No: D130-780-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53062

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Item ID: D130-780-042

Accept



Setup Start



Revision ID: B

Stop



Item Name: SPACEPOD RH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

10/09/14 JH

CL 10/9/13

Picklist Print.

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Work Order ID: 53062



Parent Item: D130-780-042RevA



Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D130-780-044RevA		Manufactured	No			110	Each	0.0000	1.0000			
------------------	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

Spacepod Door Assembly, RH

D3188-2MRevE		Manufactured	No			110	Each	1.0000	1.0000			
--------------	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

SPACEPOD BODY RH

--	--	--	--	--	--	--	--	--	--	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Main Warehouse

CA

1

46180A

1

110

Each

1.0000

28.0000

AKS4-1032-130

AKS4-1032-130		Purchased	No			110	Each	1.0000	28.0000			
---------------	--	-----------	----	--	--	-----	------	--------	---------	--	--	--

Inserts

D3837-4RevB

D3837-4RevB	X	Manufactured	No			110	Each	5.0000	1.0000			
-------------	---	--------------	----	--	--	-----	------	--------	--------	--	--	--

Decal

Page 1

TB

W/O: 53062

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-08-11	110	& add to list <u>NAS 1515 H3 x2 B 111268</u> <u>MS 27039-08-11 x2 B 113749</u> <u>D2179 x2 B 35432</u>	AT	10-08-11			10/08/11
			AA	10-09-14			

Part No: D130-780-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print.

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Work Order ID: 53062



Parent Item: D130-780-042RevA



Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2237RevD1



Manufactured

No

110

Each

81.0000

2.0000

58181



BT 10-08-11

Striker Plate

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

5

46162

5

Main Warehouse

ST022

76

50348

21

52327

55

MS20426AD4-5



Purchased

No

110

Each

7,910.000 4.0000



CT 10-08-11

Rivet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

7910

4067

1097

6733

1831

6874

4982



Picklist Print.

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Parent Item: D130-780-042RevA



Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3538-1RevA 		Manufactured		No		110	Each	24.0000	2.0000		RT	10-08-11

Hinge Bracket

55012

WarehouseLocation

Main Warehouse

ST 14

48197 14

Main Warehouse

ST111 10

50336 10

WarehouseLocation

Main Warehouse

ST 201

16895 201

AN526-832R24

Purchased

No

110179

Screw



RT 10-08-11

WarehouseLocation

Main Warehouse

ST 201

16895 201

Picklist Print

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Work Order ID: 53062



Parent Item: D130-780-042RevA



Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1149DN832J



Purchased

No

110

Each

375.0000

8.0000

115300 +8



BT 10-08-11

WASHER

WarehouseLocation

Main Warehouse

ST 375

111193 3

111359 72

112385 300

MS21042L08



Purchased

No

110

Each

407.0000

6.0000

119016 +6



BT (0-08-11)

Nut

WarehouseLocation

Main Warehouse

ST 407

110002 24

111889 51

112243 47

112492 85

112612 100

112794 100

Picklist Print

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Work Order ID: 53062



Parent Item: D130-780-042RevA



Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	---------------------	---------------	----------	------------------	---------------	--------------	-----------------	-------------	-----------------------	------------	-------------	--------

D3815-041RevA



Manufactured

No

160

Each

7.0000

2.0000



Web Assembly

WarehouseLocation

Main Warehouse

ST

7

45729

1

46356

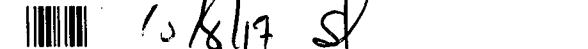
6

160

Each

7.0000

1.0000



D3837-1RevB



Manufactured

No

160

Each

7.0000

1.0000

Decal

WarehouseLocation

Main Warehouse

ST

7

46231

7

160

Each

2.0000

1.0000



D3798-042RevA



Manufactured

No

160

Each

2.0000

1.0000

Spacepod Floor

WarehouseLocation

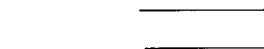
Main Warehouse

ST

2

50351

2



Picklist Print

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Work Order ID: 53062



Parent Item: D130-780-042RevA



Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3547-1RevA, 		Manufactured	No			160	Each	22.0000	1.0000		10/8/17 sf	

Bracket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

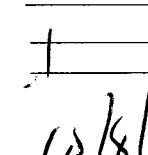
Main Warehouse

ST	22	
35455	8	
50260	14	

D3550-1RevB


Manufactured No

160 Each 17.0000 1.0000



10/8/17 sf

Strut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

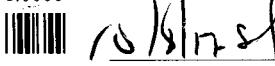
Main Warehouse

ST	17	
48367	17	

D3554-7RevA


Manufactured No

160 Each 60.0000 1.0000



Ball Stud

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	60	
37674	60	

Picklist Print.

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Work Order ID: 53062



Parent Item: D130-780-042RevA



Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3015-3RevB 		Manufactured	No			160	Each	328.0000	1.0000			B58002 10/8/14 81

Locknut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	128	
43758	26	
44446	49	
48238	53	

Main Warehouse

ST59	200	
51711	200	

AN3-3A

Bolt

Purchased

No

160 Each 161.0000 4.0000



M113359 10/8/14 58

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	161	
111925	11	
112314	50	
112720	100	

Picklist Print

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Work Order ID: 53062



Parent Item: D130-780-042RevA



Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3-6A 	Purchased	No			160	Each	135.0000	4.0000		<i>M113359</i>	<i>10/18/17 SL</i>
------------	-----------	----	--	--	-----	------	----------	--------	--	----------------	--------------------

Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	135	
112082	7	
112513	28	
112720	100	

AN3-10A 	Purchased	No			160	Each	73.0000	2.0000		<i>M115016</i>	<i>10/18/17 SL</i>
-------------	-----------	----	--	--	-----	------	---------	--------	--	----------------	--------------------

Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	73	
111119	73	

AN5-5A 	Purchased	No			160	Each	107.0000	1.0000		<i>10/18/17 SL</i>
------------	-----------	----	--	--	-----	------	----------	--------	--	--------------------

Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	107	
103585	3	
110363	4	
110865	100	

Picklist Print

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Work Order ID: 53062



Parent Item: D130-780-042RevA



Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN525-10R7

Purchased

No

160

Each

131.0000

38.0000



M13359

10/8/17 SP

Screw

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	131	_____
106166	30	_____
110844	15	_____
112314	10	_____
112411	76	_____

MS24694-S67

Purchased

No

160

Each

103.0000

7.0000



M114341

10/8/17 SP

Screw

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	103	_____
101662	13	_____
106166	1	_____
111965	89	_____

Picklist Print.

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Work Order ID: 53062



Parent Item: D130-780-042RevA



Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C832R14		Purchased	No			160	Each	937.0000	8.0000		10/8/11	

Screw

WarehouseLocation

Main Warehouse

ST

Loc QtyLoc Code

937

8

104916

937

8

MS24694-S69

Purchased

No

WarehouseLocation

Main Warehouse

ST

Loc QtyLoc Code

118

1

103574

5

1

110153

13

1

112492

100

1

A3235-020-935

Purchased

No

Each

694.0000 8.0000

10-08-11

Washer - Countersunk

WarehouseLocation

Main Warehouse

ST

Loc QtyLoc Code

694

X8

104156

3

X8

106150

691

Picklist Print

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Work Order ID: 53062



Parent Item: D130-780-042RevA



Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

V8 NAS1149D0363J



Purchased

No

160

Each

2.0000

8.0000

4

M115107 10/8/1789

Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

2

112314

2

S NAS1149D0332J



Purchased

No

160

Each

342.0000

16.0000

4

M113544 10/8/1789

Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

342

110625

16

110844

126

112794

200

S NAS1149D0563J



Purchased

No

160

Each

100.0000

3.0000

4

M114742 10/8/1789

Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

100

112794

100

Picklist Print

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Work Order ID: 53062**Parent Item:** D130-780-042RevA**Parent Item Name:** SPACEPOD RH**Start Date:** 21/10/2009**Required Date:** 04/11/2009**Comments:****Start Qty:** 1.00**Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L3



Purchased

No

160

Each

3,430.000

16.0000

Nut

m114718

10/16/11 SP

MS21042L5



Purchased

No

160

Each

1,077.000

1.0000

Nut

m114813

10/17/11 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	3430	_____
110844	32	_____
111274	35	_____
111668	863	_____
112314	2000	_____
112385	500	_____

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	1077	_____
110382	10	_____
111127	4	_____
111636	63	_____
112314	1000	_____

Picklist Print

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Work Order ID: 53062



Parent Item: D130-780-042RevA



Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AKS4-1032-130		Purchased		No		160	Each	1.0000	10.0000		M114407	18/10/18

Inserts

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

1

6087

1

D130-780-013RevA

Manufactured

No

Switch Relocation

CH9001

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

FG

2

50272

2

GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
 12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
 18 oz ROVING "E" GLASS (18 oz CLOTH)
 OWENS CORNING MILLED FIBERS, "E" GLASS
 3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
 OR DIVINYCELL
 OR AIREX
 OR KLEGECCELL
 FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

- 2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
 APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3188-1 = N/A
 D3188-2 = N/A
 D3188-3 = N/A
 D3188-5 = N/A
 D3188-6 = N/A
 D3188-7 = N/A
- 8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

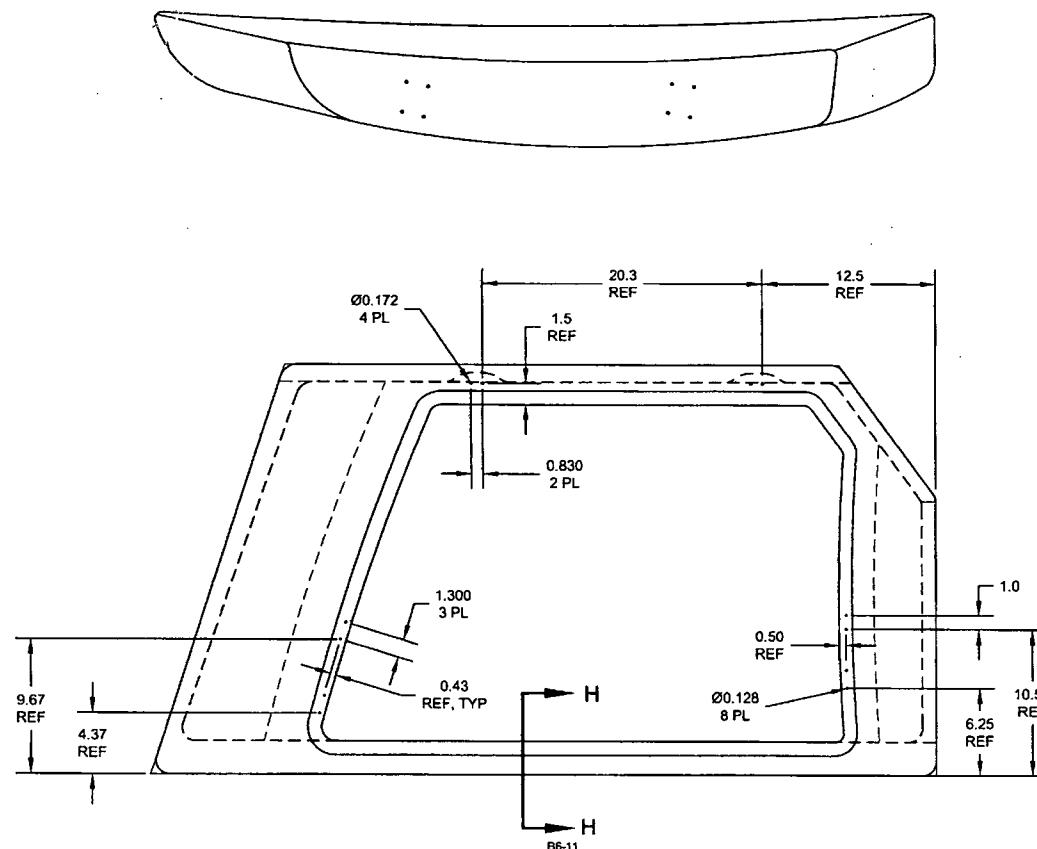
WORK ORDER

NO. 53062*Bl 09-10-22*
RELEASED
 2009-10-20
MD

F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL/ FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>✓</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>✓</i>	D3188	SHEET 1 OF 11
APPROVED	<i>✓</i>	TITLE	SCALE
DE APPR.	<i>✓</i>	SPACEPOD BODY	NTS
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[Signature]

D3188-1 SPACEPOD BODY
MAKE FROM D3188-1M

NOTES:

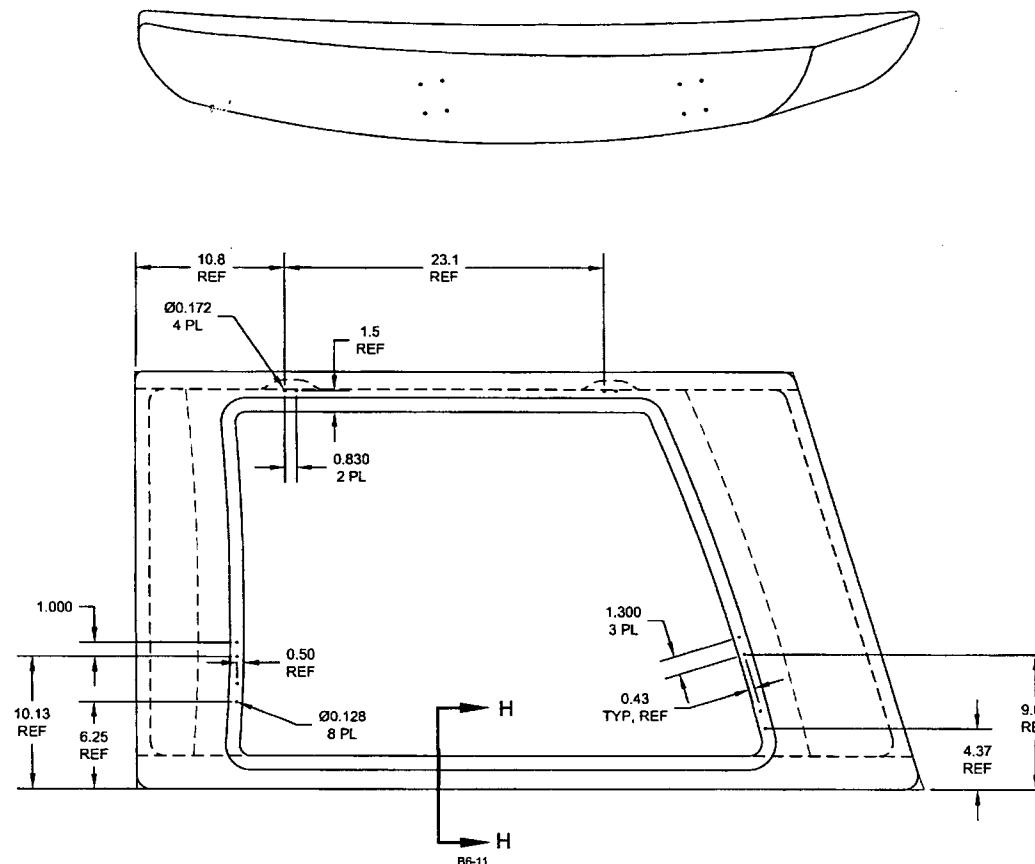
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<input checked="" type="checkbox"/>	DRAWING NO.	REV. F
MFG. APPR.	<input checked="" type="checkbox"/>	D3188	SHEET 2 OF 11
APPROVED	<input checked="" type="checkbox"/>	TITLE	SCALE
DE APPR.	<input checked="" type="checkbox"/>	SPACEPOD BODY	NTS
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D3188-2 SPACEPOD BODY
MAKE FROM D3188-2M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

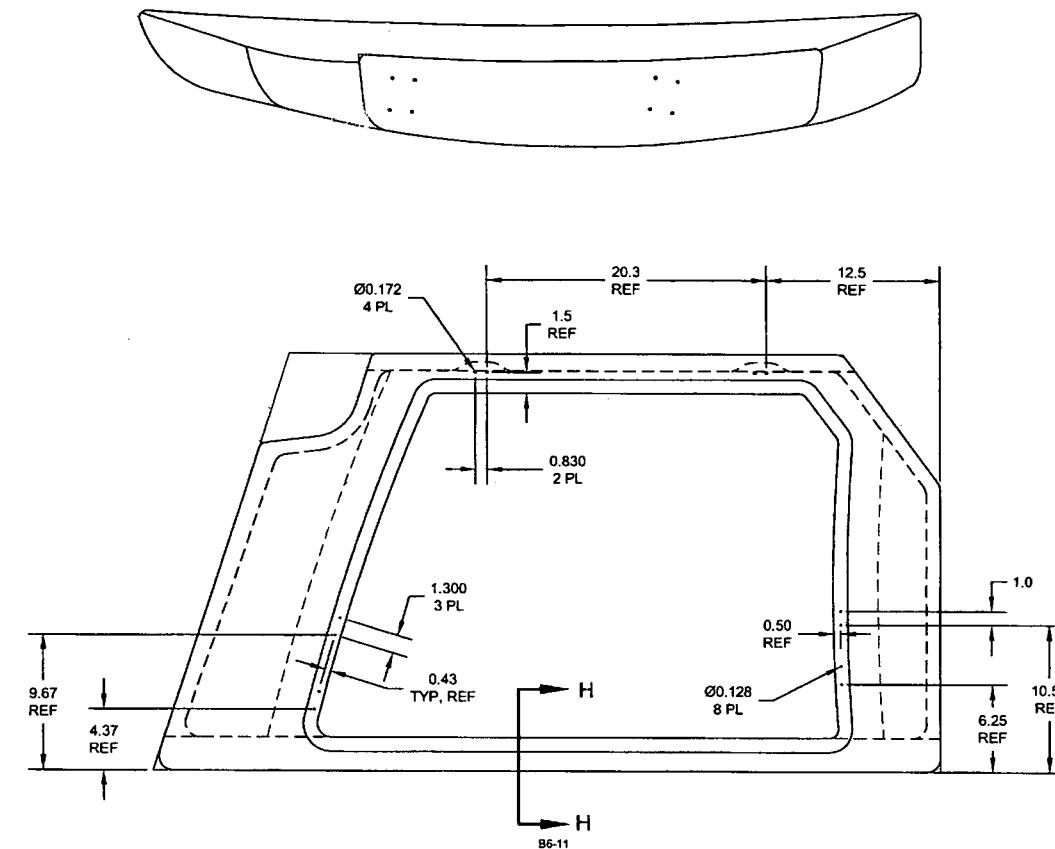
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<input checked="" type="checkbox"/>	DRAWING NO.	REV. F
MFG. APPR.	<input checked="" type="checkbox"/>	D3188	SHEET 3 OF 11
APPROVED	<input checked="" type="checkbox"/>	TITLE	SCALE
DE APPR.	<input checked="" type="checkbox"/>	SPACEPOD BODY	NTS
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2009-10-20
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8 7 6 5 4 3 2 1

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D3188-3 SPACEPOD BODY
MAKE FROM D3188-3M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
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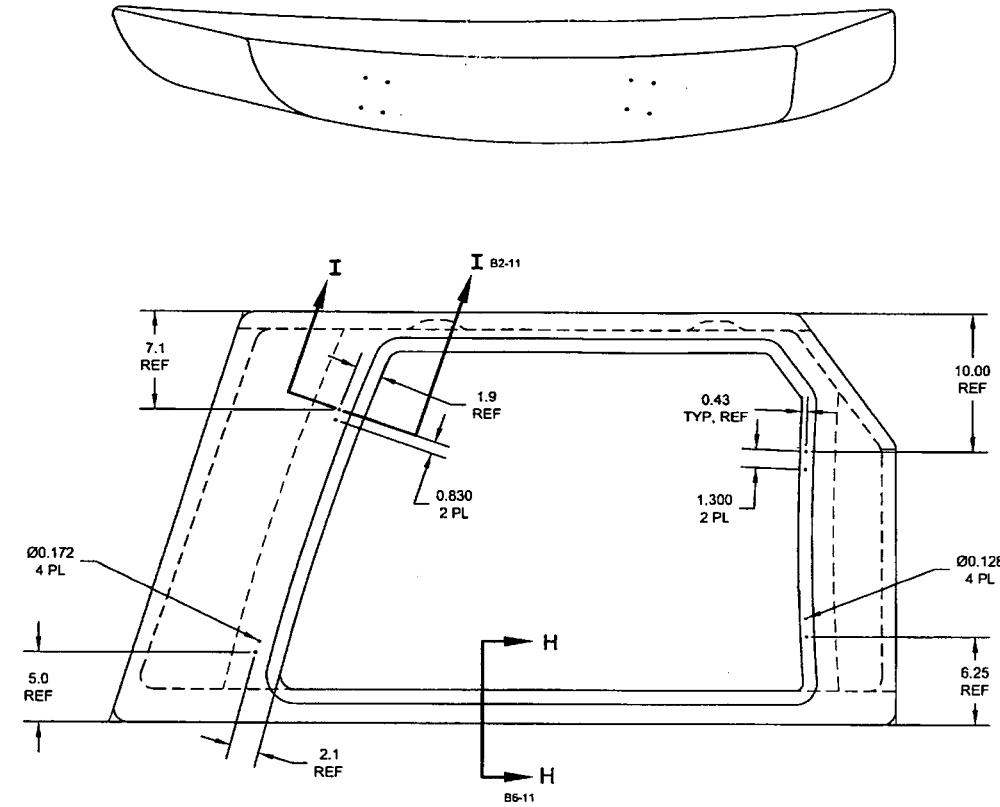
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2009-10-20
NP

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D3188-5 SPACEPOD BODY
MAKE FROM D3188-1M

RELEASED
2009-10-20
M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

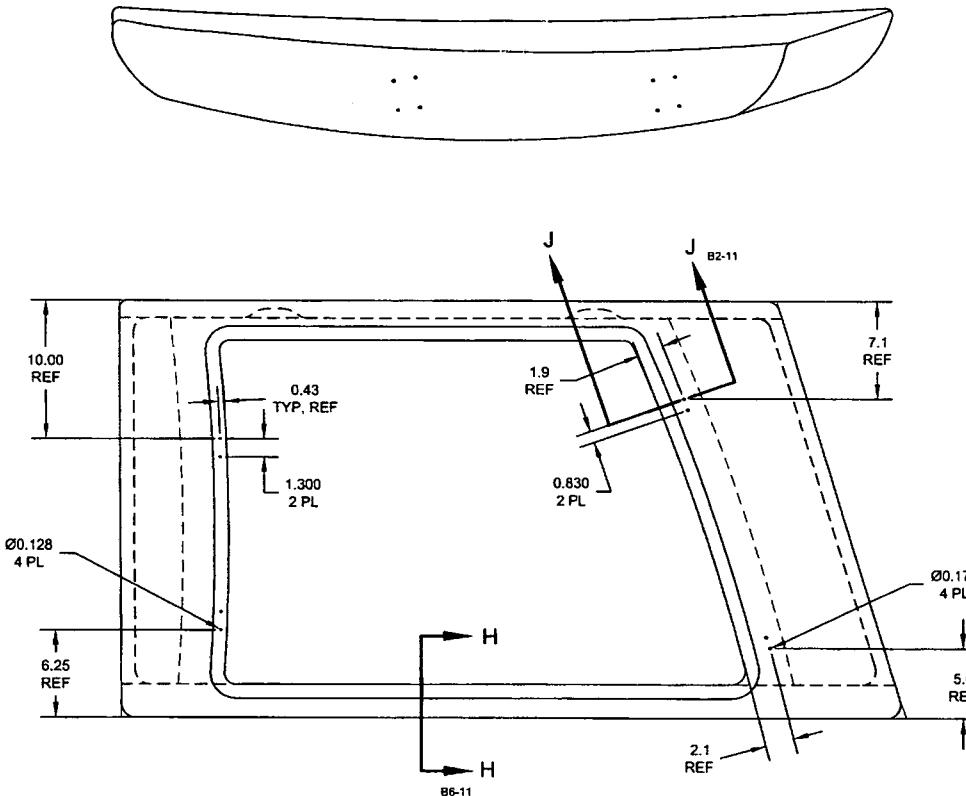
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<input checked="" type="checkbox"/>	DRAWING NO.	REV. F
MFG. APPR.	<input checked="" type="checkbox"/>	D3188	SHEET 5 OF 11
APPROVED	<input checked="" type="checkbox"/>	TITLE	SCALE
DE APPR.	<input checked="" type="checkbox"/>	SPACEPOD BODY	NTS
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8 7 6 5 4 3 2 1

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D3188-6 SPACEPOD BODY
MAKE FROM D3188-2M

RELEASED
2009-10-20
M

NOTES:

1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AA	DRAWING NO.	REV. F
MFG. APPR.	AA	D3188	SHEET 6 OF 11
APPROVED	AA	TITLE	SCALE
DE APPR.	AA	SPACEPOD BODY	NTS
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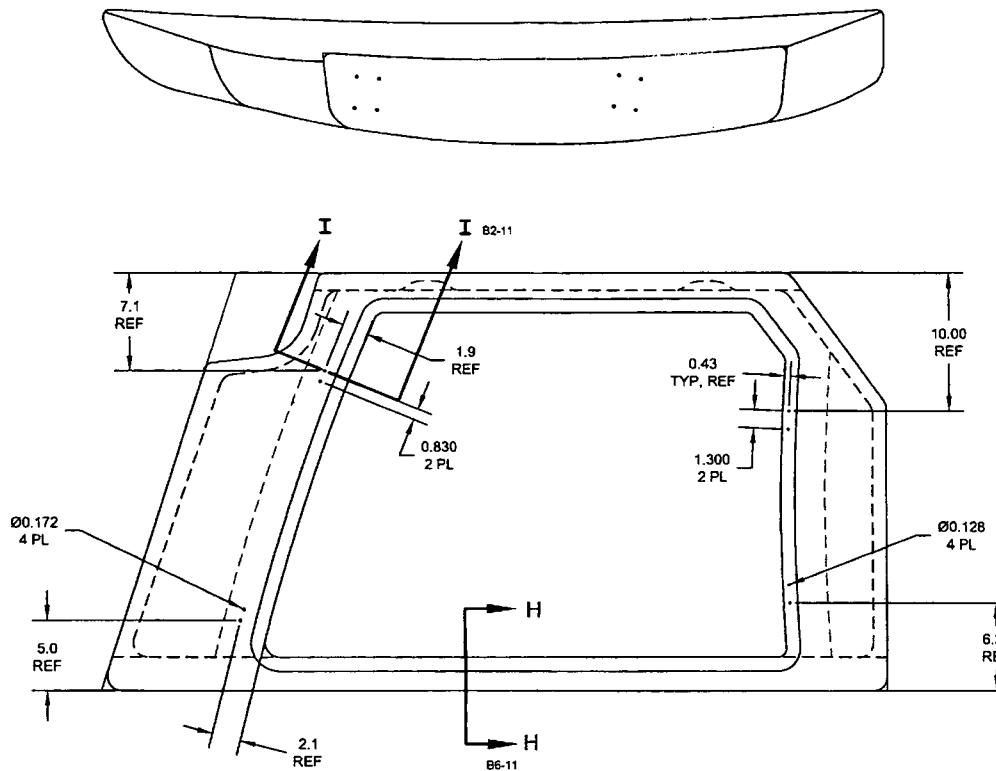
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D3188-7 SPACEPOD BODY
MAKE FROM D3188-3M

NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	REV. F	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.	
MFG. APPR.		D3188	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
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8 . 1 7 . 1 6 . 1 5 . 1 4 . 1 3 . 1 2 . 1 1 .

8 7 6 5 4 3 2 1

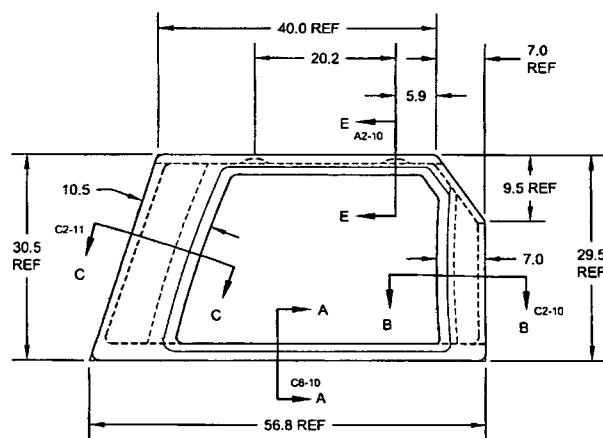
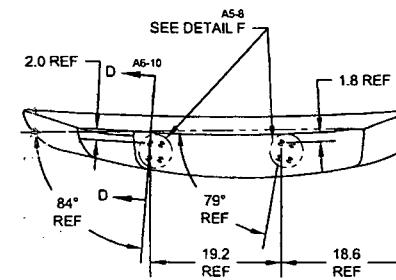
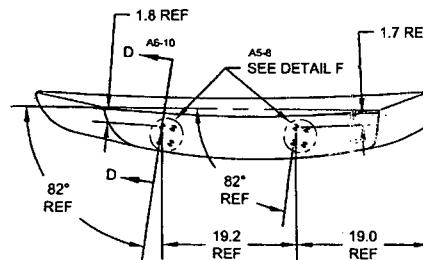
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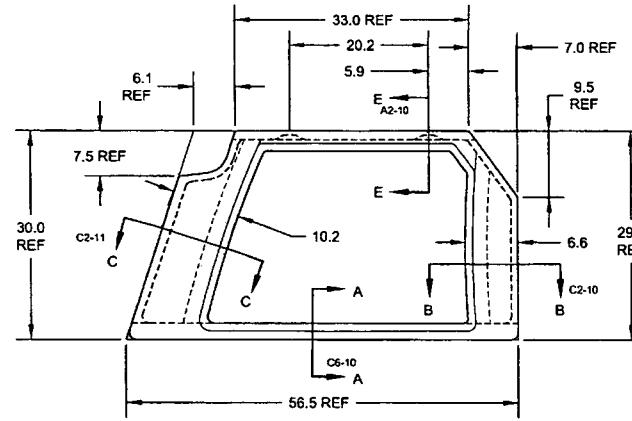
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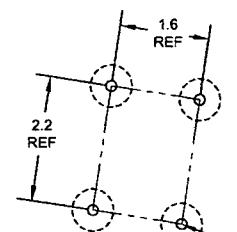


D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY

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2009-10-23
AP



DETAIL F D3-8
D7-8

INSTALL
D2213 SPACER
8 PL
SEE SECTION D-D
A6-10

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	DRAWING NO.	
MFG. APPR.	#	D3188	REV. F
APPROVED	#	TITLE	SCALE
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D3186-1M/3M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

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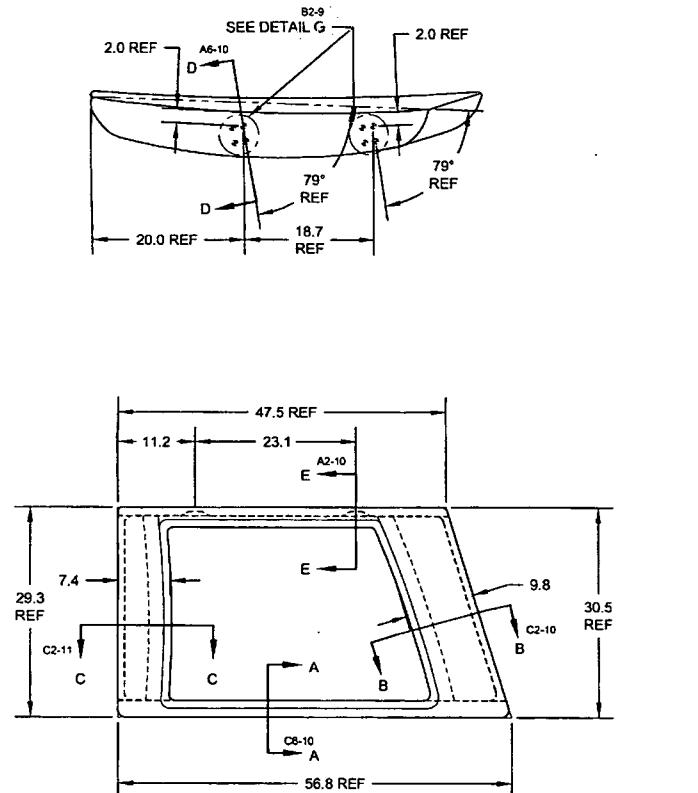
3

2

1

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D3188-2M SPACEPOD BODY

D3186-2M NOTES:

1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2) SEE SHEET #10 FOR SECTION VIEWS.

INSTAL
D2213 SPACE
8 P
SEE SECTION D-

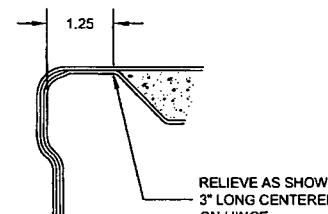
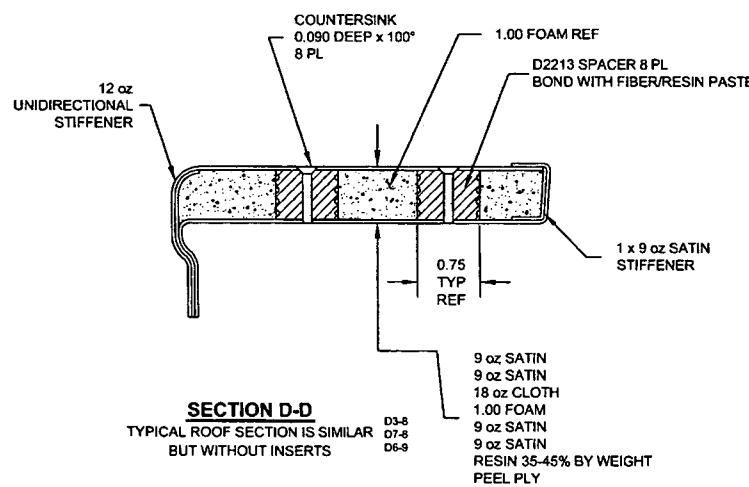
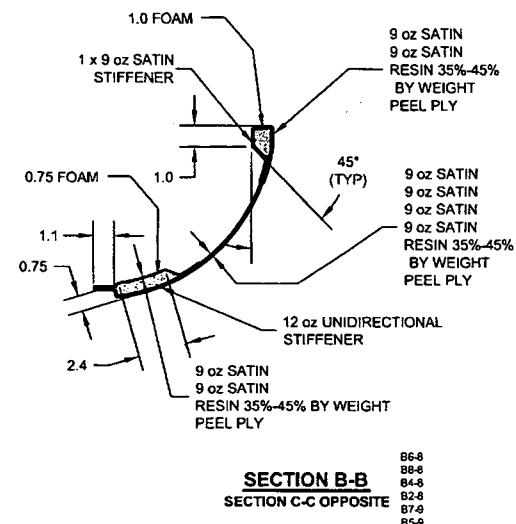
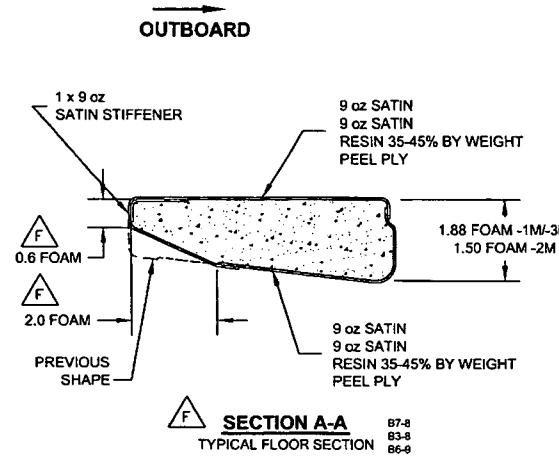
DETAIL G

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2009-10-20

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	<input checked="" type="checkbox"/>	DRAWING NO.	REV. F	
MFG. APPR.	<input checked="" type="checkbox"/>	D3188	SHEET 9 OF 11	
APPROVED	<input checked="" type="checkbox"/>	TITLE	SCALE	
DE APPR.	<input checked="" type="checkbox"/>	SPACEPOD BODY	NTS	
DATE	09.07.13			

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SECTION E-E
2 PLACES PER POD
C2-8
C7-8
B6-9

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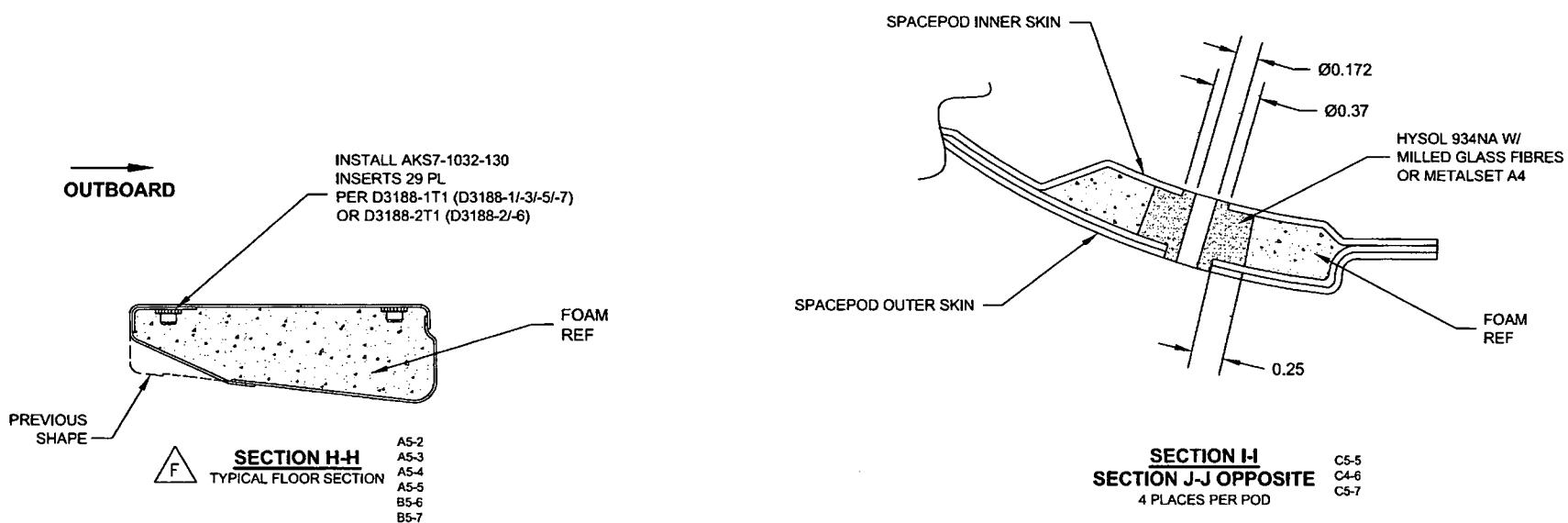
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	✓	DRAWING NO.	REV. F
MFG. APPR.	✓	D3188	SHEET 10 OF 11
APPROVED	✓	TITLE	SCALE
DE APPR.	✓	SPACEPOD BODY	NTS
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DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	DRAWING NO.	REV. F
MFG. APPR.	W	D3188	SHEET 11 OF 11
APPROVED	#	TITLE	SCALE
DE APPR.	#	SPACEPOD BODY	NTS
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5.0 PARTS LIST

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
X							D130-780-041	SPACEPOD™ LH, EC 130 B4
	X						D130-780-042	SPACEPOD™ RH, EC 130 B4
1		X					D130-780-043	DOOR ASSEMBLY, LH
1			X				D130-780-044	DOOR ASSEMBLY, RH
1				X			D130-780-011	LH SLIDING DOOR HINGE KIT
1	1				X		D130-780-013	SWITCH RELOCATION KIT
					1	X	D130-780-015	CLOSEOUT KIT
2	2						D3815-041	WEB ASSEMBLY
3	3						D3815-5	PACKER
		1	1				D2589	KEYS, KEY CHAIN
1	1						D3837-1	DECAL
1	1						D3015-3	LOCK NUT
		1					D3186-3	SPACEPOD™ DOOR, LH
			1				D3186-4	SPACEPOD™ DOOR, RH
1							D3798-041	FLOOR
	1						D3798-042	FLOOR
1							D3188-5	SPACEPOD™ BODY
	1						D3188-6	SPACEPOD™ BODY
1	1						D3547-1	BRACKET
1	1						D3550-1	STRUT
		1	1				D3552-7	GAS SPRING
1	1						D3554-7	BALL STUD
4	4						AN3-3A	BOLT
4	4						AN3-6A	BOLT
2	2						AN3-10A	BOLT
1	1						AN5-5A	BOLT
38	38						AN525-10R7	SCREW
8	8						AN526C832R14	SCREW
6	6						MS24694S54	SCREW
7	7						MS24694S67	SCREW
1	1						MS24694S69	SCREW
		2	2				MS27039-0811	SCREW
8	8						A3235-020-935	WASHER
14	14						NAS1149D0363J	WASHER
16	16						NAS1149D0332J	WASHER
		4	4				NAS1149DN832J	WASHER
3	3						NAS1149D0563J	WASHER
		2	2				NAS1515H3	NYLON WASHER
		2	2				MS21042L08	NUT
22	22						MS21042L3	NUT (or MS21042-3)
1	1						MS21042L5	NUT
10	10						AKS7-1032-130	INSERT
28**	28**						AKS7-1032-130	INSERT
10	10						MS21059L3	NUTPLATE

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-041	-042	-043	-044	-011	-013	-015	Part Number	Description
				2			D3819-1	MALE SPADE CONNECTOR
				2			D3597-1	FEMALE SPADE CONNECTOR
				1			D3598-2-096	EXPANDABLE SLEEVE
				24			D3599-1	TIE-WRAP
				24			D3600-1	TIE-WRAP MOUNT
				24 FT			M22759/41-22-9	WIRE
				1*	1*		D2464-1250	NEOPRENE SEAL
1**		1*					D3837-3	DECAL
1**		1*					D3837-4	DECAL
							D2586	LATCH
		2*	2*				D2585	MOUNTING CHANNEL
		2*	2*				D2621	LATCH PLATE
		2*	2*				MS27039-1-15	SCREW
		2*	2*				NAS1149D0363J	WASHER
		2*	2*				MS21042L3	NUT (or MS21042-3)
		1*	1*				D2857-1	HINGE BRACKET
		1*	1*				D2857-2	HINGE BRACKET
		2*	2*				D2228	BACKING PLATE
		8*	8*				AN526C832R10	SCREW
		8*	8*				NAS1149DN832J	WASHER
		8*	8*				MS21042L08	NUT
		1*	1*				D3557-1	BRACKET
		2*	2*				D2228	BACKING PLATE
		1*	1*				D3554-7	BALL STUD
		1*	1*				NAS1149D0563J	WASHER
		1*	1*				D3015-3	LOCK NUT
		2*	2*				AN526C832R14	SCREW
		2*	2*				AN526C832R10	SCREW
		4*	4*				NAS1149DN832J	WASHER
		4*	4*				MS21042L08	NUT
2**	2**						D2237	STRIKER PLATE
4**	4**						MS20426AD4-5	RIVET
2**	2**						D3538-1	HINGE BRACKET
2**	2**						D2179	HINGE BRACKET PLATE
4**	4**						AN526C832R24	SCREW
4**	4**						NAS1149DN832J	WASHER
4**	4**						MS21042L08	NUT
				1			D3813-041	HINGE ASSEMBLY, UPPER DOOR
				1			D3813-043	HINGE ASSEMBLY, LOWER DOOR
				2***			D3518-3	ROD END

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Revision: B
Date: 09.06.11

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
				2***			NAS509-6	NUT
				1			D3814-1	HINGE, UPPER AIRFRAME
				1			D3814-3	HINGE, LOWER AIRFRAME
				2			D3816-1	SPACER
				4			D3816-3	SPACER
				1			D3817-041	ANCHOR PLATE
				2			AN3-5A	BOLT
				3			AN3-7A	BOLT
				2			AN310-4	CASTLE NUT
				2			AN4-17	BOLT
				2			AN970-4	WASHER
				5			MS21042L3	NUT
				2			MS24665-212	COTTER PIN
				3			MS24694S46	SCREW
				8			NAS1149D0363J	WASHER
				2			NAS1149D0463J	WASHER
				1			D3552-7	GAS SPRING
				2			D3622-1	BALL STUD
				1			D3820-1	DOOR SUPPORT
				2			MS21042L5	NUT
			2				NAS1149D0563J	WASHER
				1			D3892-1	SEAL
					1		D3983-1	OUTER CLOSEOUT
					1		D3983-3	INNER CLOSEOUT
					1		D3983-5	HINGE CLOSEOUT
					1		D3983-047	CLOSEOUT ATTACHMENT
					1		D3983-9	SPACER
					2		AN525-10R6	SCREW
					1		AN525-10R24	SCREW
					1		NAS1149D0363J	WASHER
					1		MS21042L3	NUT

* Pre-installed on D3186-3/-4 Spacepod™ Door

** Pre-installed on D3188-5/-6 Spacepod™

*** Pre-installed on D3813-041/-043 Hinge Assemblies

DART SERVICE INSTRUCTION

REFERENCE ONLY

S

TO AMEND INSTALLATION INSTRUCTIONS IIN-D130-780 REV. B OR LATER APPROVED REVISION
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D130-780 REV. 1 OR LATER ACCEPTED REVISION

REF. TCCA STC: SH93-88

REF. FAA STC: SR00098NY

REF. EASA.IM.R.S.01292

The purpose of this DSI is to provide an alternate door prop for the D130-780-011 LH Sliding Door Hinge Kit.

In service experience has shown that LH Sliding Doors may have significantly more weight associated with their installation due to executive style finishing versus the standard utility LH Sliding Door. This extra weight requires a more powerful door prop to operate the door.

For D130-780-011 at CHG 003, the D3552-7 door prop is replaced with a D3552-13 door prop as follows:

IS	-041	-042	-043	-044	-011	-013	-015	PART NUMBER	DESCRIPTION
					1			D3552-13	DOOR PROP

WAS	-041	-042	-043	-044	-011	-013	-015	PART NUMBER	DESCRIPTION
					1			D3552-7	DOOR PROP

Customers with D130-780-011 at CHG 002 or earlier, may procure the DSI 9502-011 kit to replace the D3552-7 door prop with a D3552-13 door prop as follows:

-011		
X	DSI 9502-011	REPLACEMENT DOOR PROP KIT
1	D3552-13	DOOR PROP

- 1) Remove the D3552-7 door prop from the ball studs
- 2) Install the D3552-13 per IIN-D130-780 and ICA-D130-780.
- 3) Update parts list in IIN-D130-780 and ICA-D130-780 to reflect the part number change.
- 4) Make an entry in the technical record of the aircraft indicating that DSI 9502 has been accomplished.

Weight and Balance change associated with this DSI is negligible.

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED	
BY:	
D. SHEPHERD (DE # 02)	
DATE:	10.02.03
CERT. NO.:	SH93-88
ISSUE NO.:	6

A	NEW ISSUE		10.02.03
REV.	DESCRIPTION		DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9502	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		REPLACEMENT DOOR PROP NTS	
DATE	10.02.03		

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